

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005453**Date Inspected:** 17-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** XU YUAN PING**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #07

This QA Inspector randomly observed ZPMC welding personnel performing Fillet welding of weld joint BP-158-001- W7/8,W11/12&W15/16 filler passes. The personnel were observed welding in the 2F position utilizing a FCAW process. Welders are identified as 051246,205774&054459. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2132 – 3.

This QA Inspector randomly observed ZPMC welding personnel performing Fillet welding of weld joint BP-131-001-W7/8,W11/12&W15/16 filler passes. The personnel were observed welding in the 2F position utilizing a FCAW process. Welders are identified as 209554,205774&054459. The welding variables recorded by QC appeared to comply with the WPS- B – T – 2132 – 3.

Bay #7

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC

WELDING INSPECTION REPORT

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Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as SP377-001-051/53,SP323-001-056/58,SP110-001-060/62

Magnetic Perticle Testing

OBG SEGMENT 04AW

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 04AW.

The weld designations reviewed are as follows:

SSD-29-PP-24.5 - 51/52,53/54,55/56,83/84,85/86,97/98,99/100,101/102

SEG-017B-12

SEG-017C-12

SSD-13- 38/39,40/41,42/43,54/55,56/57

SSD-13A - 38/39,40/41,42/43

SSD-13-8/10

SSD-13A-8/10

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
